



NOTE

This procedure is not for the SE-16

1. Procedures for Infrared Sensor

A. Turn the **MODE** switch to the **MANUAL** position or to the **SERVO-CENTER** position (if installed).

B. Turn AC power on.

NOTE

If the system has the Servo-Center feature, the guide should move to the middle of its stroke and stop. In the **MANUAL** position, the guide will remain stationary.

NOTE

If there is only one sensor, do not attempt to operate the guide in the center guiding configuration. Also, a single sensor can be used in either position only if the cable is connected to the proper port on the signal processor.

NOTE

For the A9 series check the setting of the **POLARITY** switch (S402) on the sensor interface PCB assembly. Ensure that the **POLARITY** switch (S402) is in the center (**OFF**) position. For the A9A series, ensure that the **POLARITY** switch (S403) is in the (**OTHERS**) position.

D. Thread the web through the sensor.

E. Ensure that the web is tight and ready to move.

F. Loosen the sensor locking knob and position the sensor so the web edge is centered over the sensing area in line with the guide point arrow on the sensor.

G. Secure the sensor locking knob.

NOTE

For center guiding with two sensors, repeat steps F. and G. for the other side of the web.

H. Adjust system sensitivity as follows:

- (1) Turn the **GAIN** control all of the way counterclockwise to its least sensitive position.
- (2) Turn the **GAIN** control clockwise one-fourth turn.
- (3) Adjust the **GUIDE POINT** control on the panel until the **NULL** indicator darkens or both colors of the indicator are dimly illuminated.

NOTE

If the web is too far to one side of the guide point, the red LED will be illuminated. If the web is too far to the other side, the green LED will be illuminated. If the web is at the guide point, both LEDs will be extinguished or darkened considerably.

I. Turn the **MODE** switch to the **AUTO** position.

NOTE

The system is now in the **AUTO** guiding mode and any lateral movement of the web will result in a corresponding correction by the system.

WARNING

TO AVOID PERSONAL INJURY, SHUT DOWN THE PROCESS LINE DURING THE FOLLOWING PROCEDURE.

J. Check the system sensitivity by slowly passing an opaque piece of material through the sensing area laterally to simulate web movement. Turn the **GAIN** control clockwise to increase sensitivity of the system.

NOTE

If the system overcorrects (goes past the guide point) or begins to vibrate, the **GAIN** control is set too high. To lower the setting, turn the **GAIN** control counterclockwise until the system does not over-compensate.

K. If the system has the optional **REMOTE GUIDE POINT SHIFT ASSEMBLY** control, the **GUIDE POINT** control on the operator panel can be considered to be a coarse adjustment. The fine adjustment control is the **REMOTE GUIDE POINT SHIFT ASSEMBLY** control that is normally located at the delivery end of the process.

L. With the web moving, adjust the **REMOTE GUIDE POINT SHIFT ASSEMBLY** control as necessary to meet the requirements of the specific manufacturing operation.

CAUTION

WHEN THE GUIDE POINT IS SET, THE WEB EDGE SHOULD BE NEAR THE CENTER OF THE SENSING AREA. IF THE WEB EDGE IS TOO FAR FROM CENTER, THE RESULT COULD BE THAT THE WEB

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IS ADJUSTED OUT OF THE SENSOR RANGE AND THE ABILITY OF THE SYSTEM TO GUIDE WILL BE LOST.

2. Changing Sensor Configuration

If it is necessary to change a center guide system to the edge guide configuration or change from one edge to the other, proceed as follows:

- A. Place the **MODE** switch in the **MANUAL** position.
- B. Change the **SENSOR SELECT** jumper on the **MAIN BOARD** from 1 to 2 or 2 to 1.
- C. Accomplish the procedures in step 1.

NOTE

It is necessary to readjust the guide point each time the sensor configuration is changed.